

Work Order ID 67322

Tuesday, March 15, 2011 10:16:58 AM



Page 1

Item ID: D412-698-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Support

Start Date: 3/15/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

K

Date:

11-03-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-698	Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-015 CHG001

Sx1103/21

JG for BG 11-3-18 (4)

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/3/18

(4) Pro →

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Sx1103/21

(4)

W/O: 67322		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/03/21	#110	Perm. Change Add Qty to P.I. per kit under Qty per kit column.	<i>[Signature]</i>	11.03.21			<i>[Signature]</i> 11/03/21

Part No: D412-698-015 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67322

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Item ID: D412-698-015

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Setup Start



Revision ID:

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Item Name: Door Support

Start Date: 3/15/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging	Packaging	0.00				11/3/21			40
Packaging	Memo Identify and pack for shipping as per PPP D412-698- 015 Location: <u>22</u> □ PPP Rev: <u>A</u>	0.00							
140 QC	QC21- Final Inspection - Work Order Release	0.00						11/3/21	
Quality Control	Memo	0.00							

11-03-21
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 15, 2011 10:17:05 AM

Page 1

Work Order ID: 67322

Parent Item: D412-698-015

Parent Item Name: Door Support



Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing 06-01-25 JLM
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN960JD10L	NAS1149D0332J	Purchased	No				Each	4.0000	712	48			
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Washer

Location	Loc Qty	Loc Code
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ST335

4

11912

4

Manufactured No

Each

28.0000



Door Post Block

Location	Loc Qty	Loc Code
----------	---------	----------

ST040

24

64780

24

ST044

4

64494

4

Manufactured No

Each

17.0000



Door Wedge

Location	Loc Qty	Loc Code
----------	---------	----------

ST040

17

64779

17

Manufactured No

Each

20.0000



Doubler

Location	Loc Qty	Loc Code
----------	---------	----------

ST040

20

64495

5

66678

15

11/17/10 11/3/12 SP

11/3/12 SP

11/3/12 SP

11/3/12 SP

5
3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 15, 2011 10:17:05 AM

Work Order ID: 67322

Parent Item: D412-698-015

Parent Item Name: Door Support

Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 4.00

Required Qty: 4.00



D3201-3
Doubler

Manufactured No

Each

25.0000



11/3/10

SL

Location

Loc Qty

Loc Code

ST041

25

63245

9

66679

16

Manufactured No

Each

-22.0000



11/3/10

SL

Location

Loc Qty

Loc Code

ST040

6

63246

6

ST041

16

66680

16

Purchased No

Each

2,342.000



11/3/10

SL

Location

Loc Qty

Loc Code

ST300

2342

116391

742

116540

800

116549

800

Purchased No

Each

62.0000



11/3/10

SL

42

Location

Loc Qty

Loc Code

ST288

62

116361

62



MS21042L3
Nut



MS24693-S277
Screw

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1 /	DOOR POST BLOCK
2		D3200-3 /	DOOR WEDGE
2		D3201-1 /	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
2		AN960JD516L	WASHER
12		MS21042L3	NUT, (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: E

Date: 08.05.01